107196

Item ID:	D3488-041		Accept	***N9000401nn***	Setup	Start	***NS1***
Revision ID:						Stop	***NS2***
Item Name:	Blade Fitting LH						

Start Date:	9/23/13	Start Qty: 12.00	***12***	Cust Item ID:	
Required Date: 9/23/13		Req'd Qty: 12.00	***12***	Customer:	

Reference:

					Run	Start	***NR1***
Approvals:	Process Plan: _____ /p	Date: 13-09-23	Tooling: _____	Date: _____		Stop	***NR2***
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____			

Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**									
D3488	Rev B									
DSK101	REV D									
100 ***100*** Doosan Doosan Lathe	DOOSAN LATHE Memo 1-Turn as per Dwg DSK 101 & Folio FA625 2-Deburr		0.00 0.00				12	0		SA 13-11-11
110 ***110*** QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo		0.00 0.00				12	0		SA 13-11-11

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐   Crosstube ☐   Water Jet ☐   Engineering ☐
Machining ☐   Small Fab ☐   Prod. Eng. Coor. ☐   Quality ☐
Thermoforming ☐   Finishing ☐   Rec/Store/Packaging ☐   Other ☐
Large Fab ☐   Composite ☐   Supplier ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

_____
_____
_____

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Item ID:	D3488-041			Accept	*N9000401OO*	Setup	Start	*NS1*

Revision ID:

Item Name: Blade Fitting LH —— Stop *NS2*

Start Date:	9/23/13	Start Qty: 12.00	*12*	Cust Item ID:
Required Date: 9/23/13	Req'd Qty: 12.00	*12*		Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 **Memo** 1-Machine as per Folio FA625 & Dwg D34882-Deburr	0.00 0.00				12	0		JL 13-11-19
130 *130* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				12	0		JL 13-11-19
140 *140* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00				12	0		

of 13/11/20

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	**DISPOSITION**		**AGAINST DEPARTMENT/PROCESS**				
Part No. _____	Rework ☐		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	
	Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
NCR No. _____	Work Order Update ☐		Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

107196

Item ID:	D3488-041		Accept	***N9000401 00***	Setup	Start	***NS1***
Revision ID:						Stop	***NS2***
Item Name:	Blade Fitting LH						

| Start Date: | 9/23/13 | Start Qty: | 12.00 | *12* | Cust Item ID: | |
| Required Date: | 9/23/13 | Req'd Qty: | 12.00 | *12* | Customer: | |

Reference:

						Run	Start	***NR1***
Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____			Stop	***NR2***
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____				

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 ***150*** HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00							
	Memo	0.00				*12*	*0*	*CF*	*13-11-21*
160 ***160*** Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum *M 126 804*	0.00							
	Memo STARTIME: *3.40* OVEN TEMPERATURE: *820°* FINISH TIME: *4.10.*	0.00				*12*	*0*	*13-11-21.*	**DAS 34 9-89**
170 ***170*** QC Quality Control	QC3- Inspect Part Finish	0.00							
	Memo	0.00				*10 LH*		*13/12/19*	

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	**DISPOSITION**		**AGAINST DEPARTMENT/PROCESS**				

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____
_____
_____
_____

		Accept	***N9000401 00***	Setup	Start	***NS1***

Item ID: D3488-041

Revision ID:

Item Name: Blade Fitting LH   Stop   ***NS2***

Start Date: 9/23/13	**Start Qty:** 12.00	***12***	**Cust Item ID:**
Required Date: 9/23/13	**Req'd Qty:** 12.00	***12***	**Customer:**

Reference:

Run   Start   ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop   ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 ***180*** HandFinish Hand Finishing	HandFinishing Memo Install Inserts as per Dwg D3488	0.00 0.00							
190 ***190*** QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							DAS 34 9-89
200 ***200*** Packaging Packaging	Identify as per dwg & Stock Location: F12.001 Memo	0.00 0.00							

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

Item ID:	D3488-041		Accept	*N9000401000*	Setup	Start	*NS1*
Revision ID:							
Item Name:	Blade Fitting LH					Stop	*NS2*

Start Date:	9/23/13	Start Qty: 12.00	*12*	Cust Item ID:
Required Date: 9/23/13		Req'd Qty: 12.00	*12*	Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

Handwritten: Rm 13/12/30

Handwritten: MF 13-12-30

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____
Part No. _____
NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio

- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions

- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge

- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled

- ☐ Other _____
- _____
- _____
- _____

Work Order ID:	107196								
Parent Item:	D3488-041						Start Date: 9/23/13	Required Date: 9/23/13
Parent Item Name:	Blade Fitting LH						Start Qty: 12.00	Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-02-28 JLM
IPP Rev:B As per Rev B 06-03-30 JLM
IPP Rev:C Now On Doosan Lathe JLM   Verified BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225 Insert		Purchased	No				Each	386.0000		**48** MI23092 (xJ8)			

A4S4-1032-225

	Location	Loc Qty	Loc Code
	FG	100	
	118520	100	
	FP001	11	
	118520	6	
	122290	5	
	ST281	275	
	100896	135	
	122333	140	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6103-003 Round Billet, Aluminum		Manufactured	No				Each	22.0000		12		13-11-9	

	Location	Loc Qty	Loc Code
	MAT043	22	
	95020	4	
	96416	2	
	99312	8	
	99651	8	

108417   12

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
NCR No. _____	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

DART AEROSPACE LTD			Work Order:	*187196*
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2			Part Number:	D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D				Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article**   [ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
		Lathe Section				
Ø2.150	+/-0.005	2.149	✓			
Ø2.780	+/-0.005	2.780	✓			
Ø3.125	+/-0.010	3.123	✓			
Ø3.346	+/-0.010	3.345	✓			
0.125 x 45°	+/-0.010 x +/-0.1°	125X45°	✓			
8.000	+0.030/-0.000	8.015	✓			
9.250	+/-0.010	9.250	✓			
0.188	+/-0.010	.187	✓			
R0.032	+/-0.010	R.032	✓			
R0.062	+/-0.010	R.060	✓			
Ø0.297	+0.005/-0.001	.299	✓			
Ø0.430	+/-0.010	.432	✓			
0.100	+/-0.010	.100	✓			
0.125	+/-0.010	.130	✓			
2.620	+/-0.010	2.620	✓			
3.500	+/-0.010	3.500	✓			
1.005	+/-0.010	1.005	✓			
Ø0.484	+0.005/-0.001	.484	✓			
1.180	+/-0.010	1.180	✓			
3.150	+/-0.010	3.150	✓			
3.070	+/-0.010	3.070	✓			
R0.063	+/-0.010	R.060	✓			

13-17-10

-.254
+.063

DART AEROSPACE LTD		Work Order:	*101196*
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2		**Part Number:**	**D3488-1**
Inspection Dwg: D3488 / DSK101 **Rev:** B / D			Page 2 of 2

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section					
Ø0.508	+0.006/-0.001	.508	✓		Vern	JL-10
0.750	+/-0.010	.751	✓		H-G	
1.500	+/-0.010	1.500	✓		Vern	~
11.18	+/-0.030	11.173	✓		H-G	
R0.062	+/-0.010	.062	✓		R-G	
0.125	+/-0.010	.121	✓		Vern	~
0.590	+/-0.010	.589	✓		H-G	
0.793	+/-0.010	.790	✓		~	
1.351	+/-0.010	1.354	✓		~	
1.317	+/-0.010	1.317	✓		Vern	~
1.802	+/-0.010	1.804	✓		H-G	

Measured by:	JL	Audited by:		Prototype Approval:	N/A
Date:	13-11-19	Date:	13/11/20	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	06.03.31	New Issue		KJ/JLM	
B	08.09.19	Reformat	P/O D3488-041	KJ/JLM	
C	08.12.02	Dimension 8.000 removed		KJ/JLM	

SECTION B-B

49° 41°
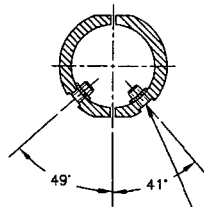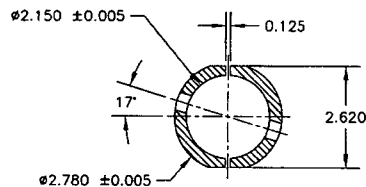
Ø0.297
C'BORE Ø0.430 x 0.100
INSTALL ALS4-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
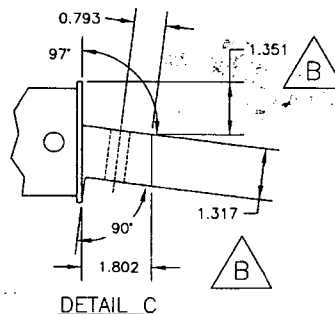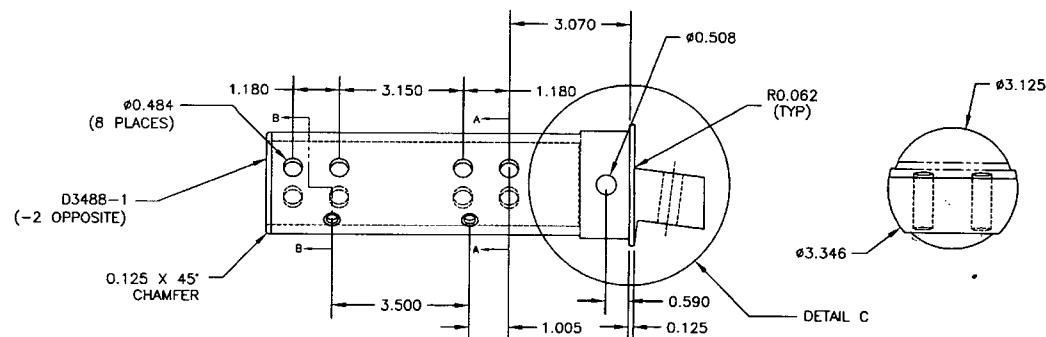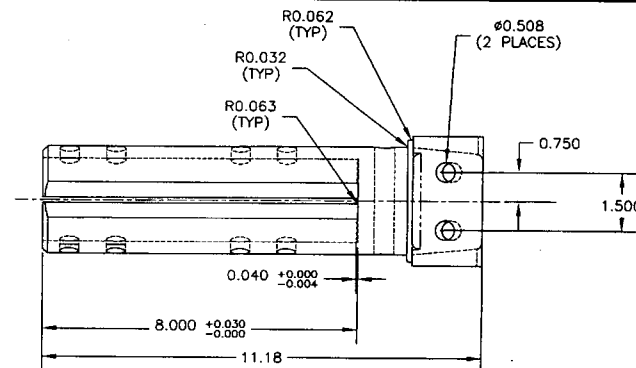INSERTS AFTER FINISH
(4 PLACES)
△4

Ø2.150 ±0.005
0.125
17°
2.620
Ø2.780 ±0.005

SECTION A-A

R0.062 (TYP)
R0.032 (TYP)
R0.063 (TYP)
Ø0.508 (2 PLACES)
0.750
1.500
0.040 +0.000 -0.004
8.000 +0.030 -0.000
11.18

3.070
Ø0.508
1.180 3.150 1.180
Ø0.484 (8 PLACES)
B   A
R0.062 (TYP)
D3488-1 (-2 OPPOSITE)
B   A
0.125 X 45° CHAMFER
3.500
1.005
0.590
0.125
DETAIL C

Ø3.125
Ø3.346
DETAIL C

0.793
97°
1.351
B△
90°
1.317
1.802
B△

DETAIL C

D3488-041 SHOWN (D3488-042 OPPOSITE)

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3488-041	BLADE FITTING ASSEMBLY (LH)
	X	D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING
1) MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR
                PER QQ-A-225/9
                (REF. DART MATERIAL SPEC M7075T73R)
2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1.
                POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
4) INSTALL INSERTS AFTER POWDER COAT
5) ALL DIMENSIONS ARE IN INCHES
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| B | | 06.03.15 | CHANGE THICKNESS |
| A | | 05.12.20 | NEW ISSUE |

DESIGN PH	DRAWN BY PH	**DART** DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3488 REV. B SHEET 1 OF 1
DATE 06.03.15		TITLE BLADE FITTING SCALE 1:3

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC.		
		PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.		REV. D
		DSK 101		SHEET 1 OF 1
DATE		TITLE		SCALE
06.05.09		D3488-1/-2 TURNING DETAIL		1:3
A		05.12.21	NEW ISSUE	
B		06.03.02	ADD TOLERANCES AND RADIUS	
C		06.04.17	0.188 WAS 0.125	
D		06.05.09	REMOVE DIAMETER FOR CHAMFER	

DART

0.188 △C

12.50

9.250

8.000 +0.030 −0.000

0.040 +0.000 −0.004

R0.032

R0.062 △B

0.125 X 45° CHAMFER

Ø2.150±0.005 △B

Ø3.346

Ø3.125

Ø2.780±0.005 △B
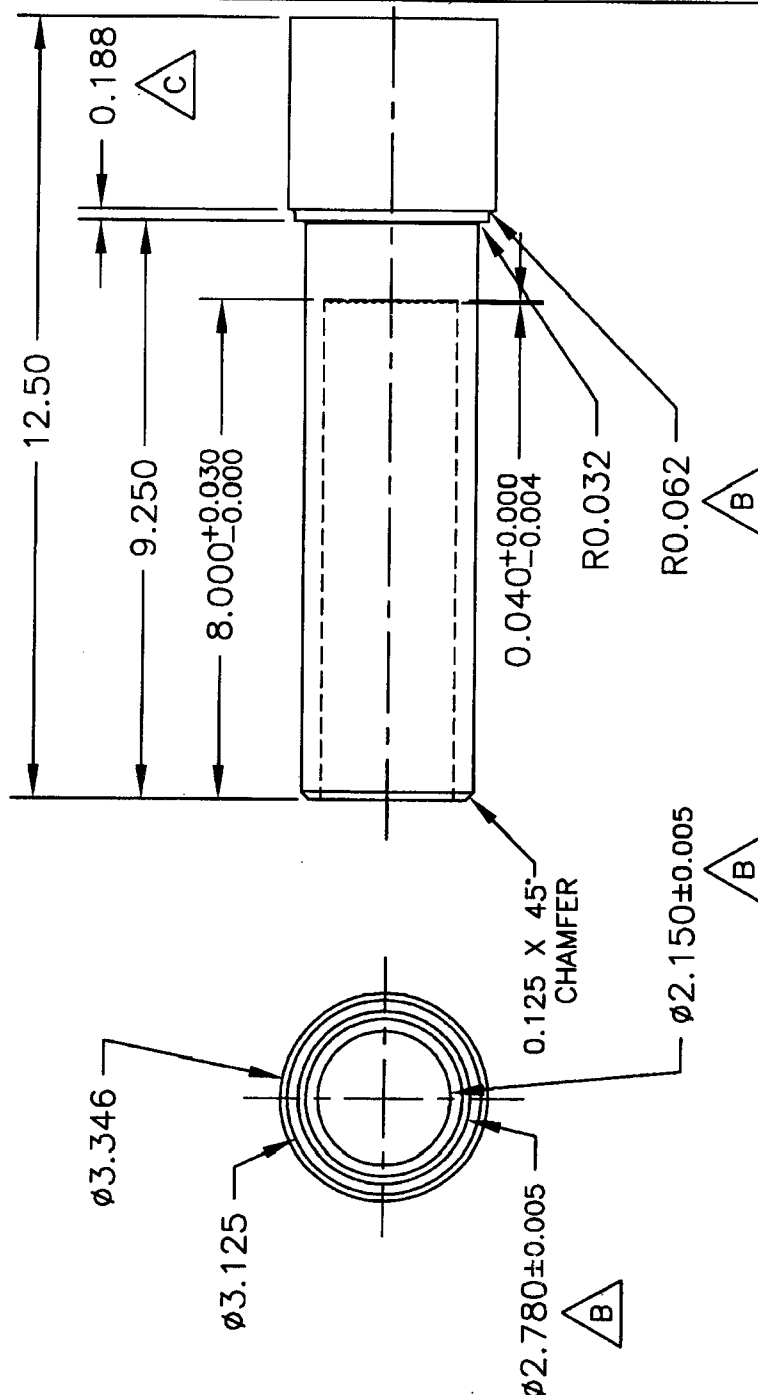
MAKE FROM ALUMINUM 7075−T7351 ROUND BAR PER QQ−A−225/9
(REF. DART MATERIAL SPEC M7075T73R)

DSK 101
1) MATERIAL:
2) FINISH: NONE
3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED